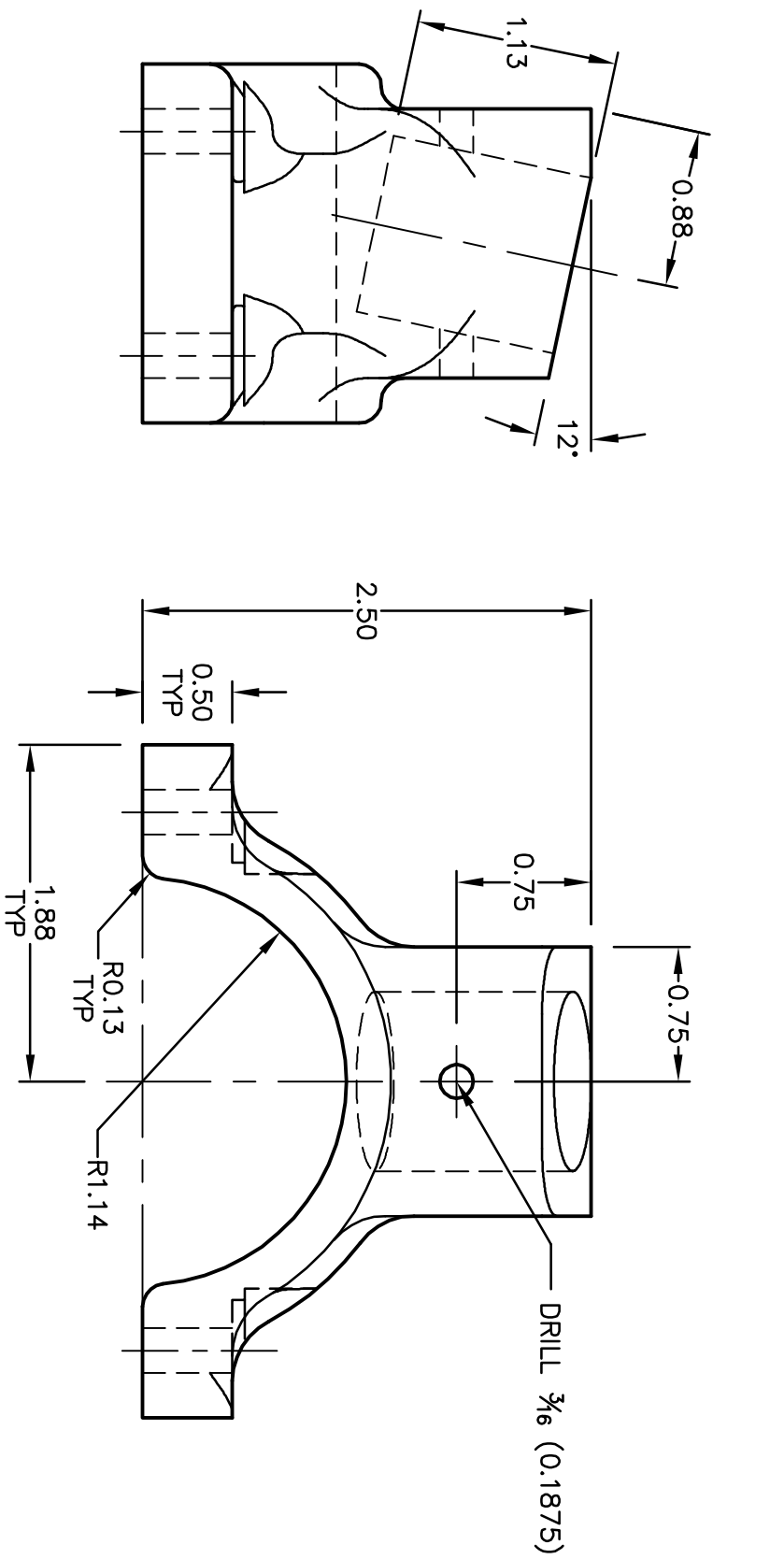
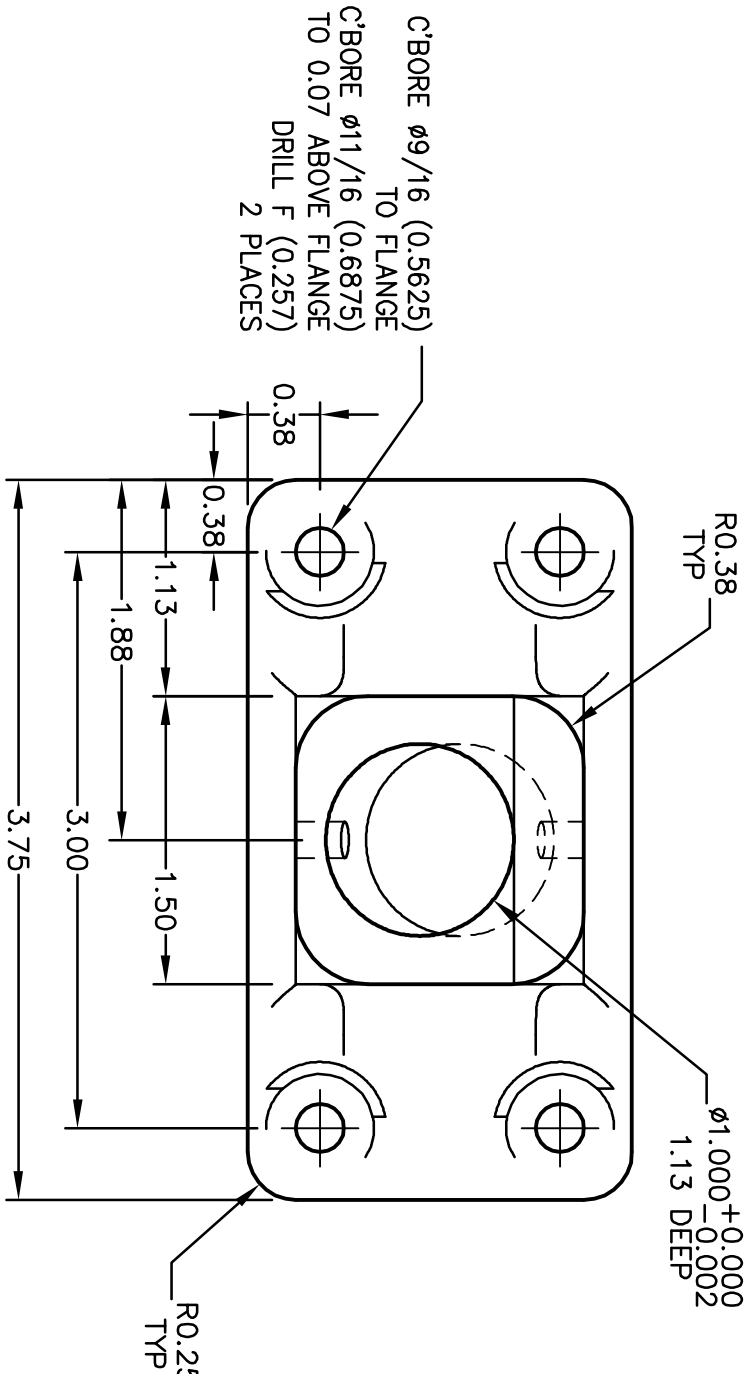
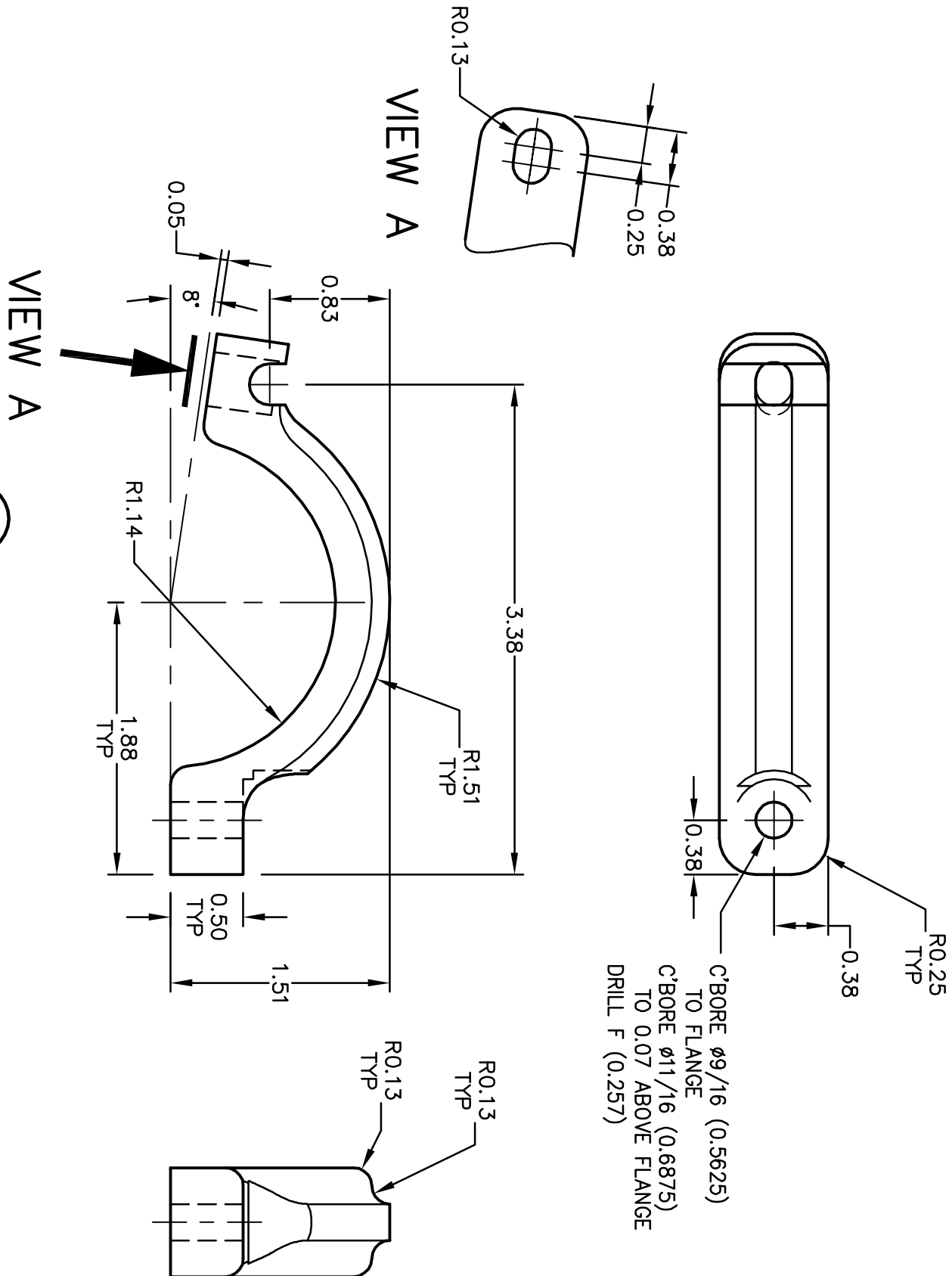


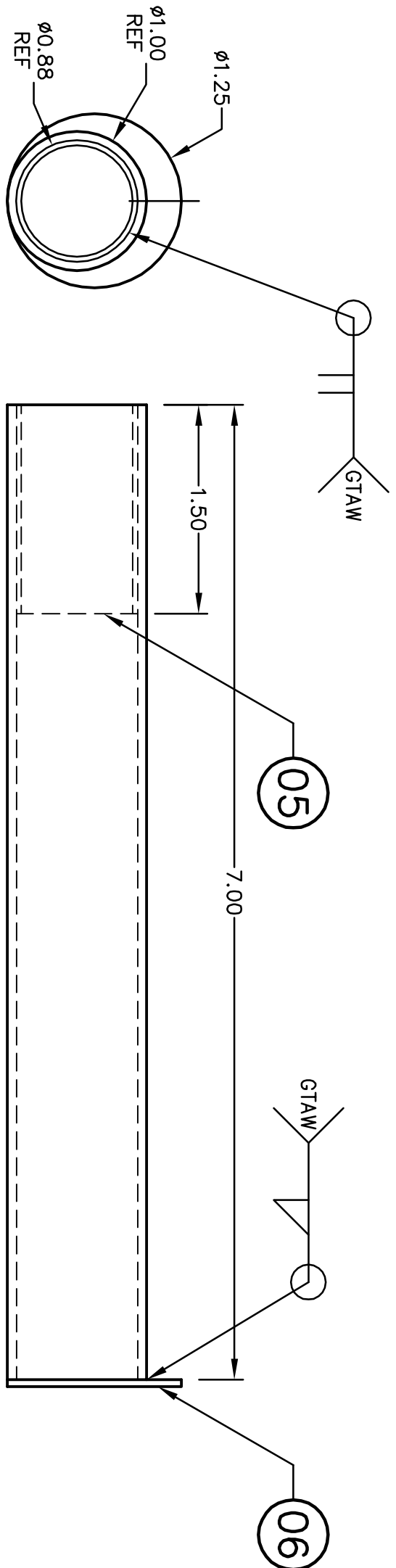
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	CHANGE TO 2 CLAMP ATTACHMENT	B/C	MAY 10/10
2	TITLE BLOCK UPDATED: CAP MATERIAL UPDATED: HARDWARE UPDATED	B/C	18/07/2014
	POWDERCOAT FINISH ADDED: GRIP PAINT REPLACED WITH TAPE		



02 SOCKET



03 CLAMP

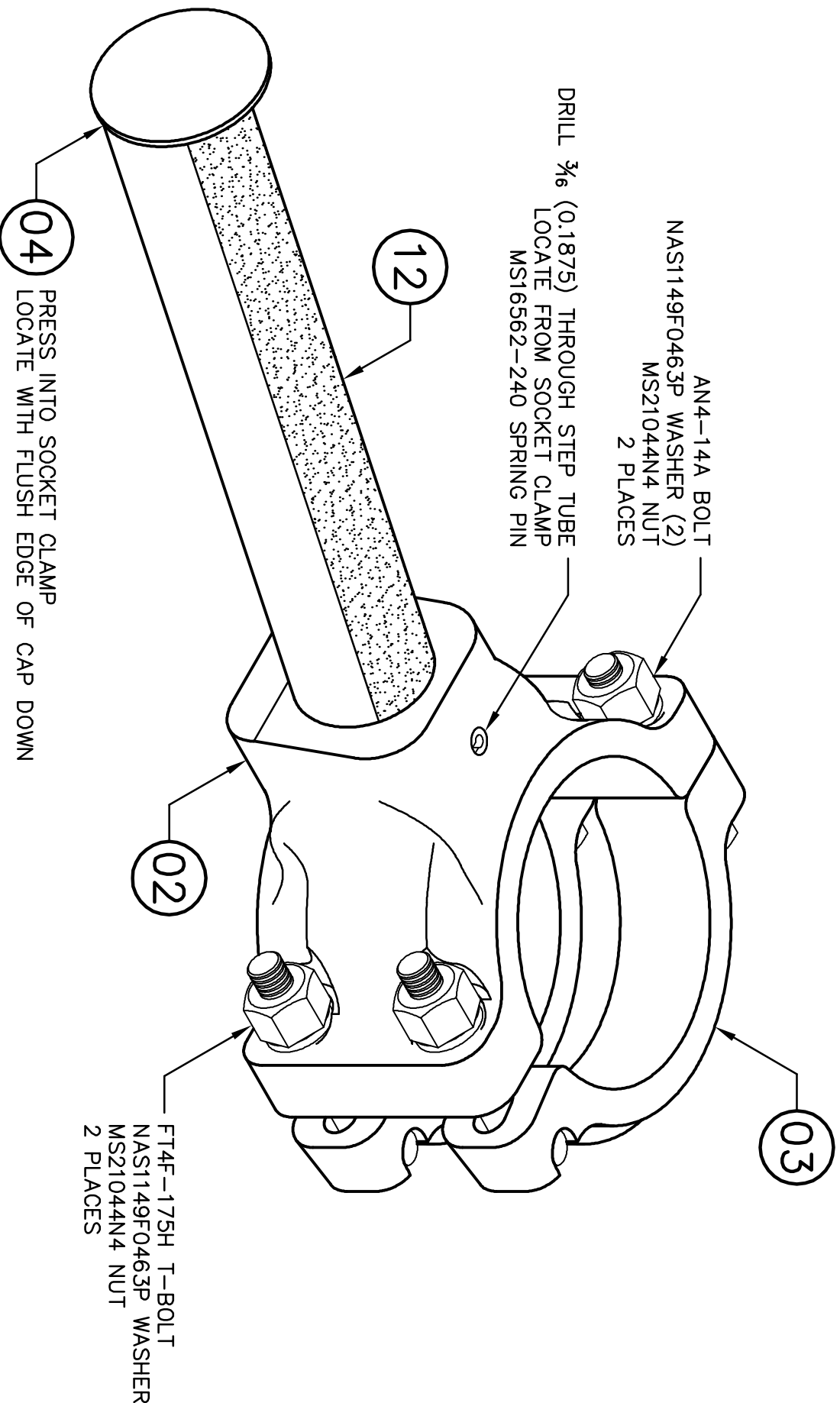


04 STEP TUBE

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	82740-12	12	GRIP TAPE			1.0 WIDE
1	MS16562-240		SPRING PIN			
4	MS21044N4		NUT			
6	NAS1149F0463P		WASHER			
2	AN4-14A		BOLT			
2	FT4F-175H		T-BOLT			
1	82740-06	06	CAP	304 STAINLESS STEEL	AMS 5913	0.050 SHEET
1	82740-05	05	TUBE	304 STAINLESS STEEL	ASTM A213	0.875 X 0.035 RND. TUBE
1	82740-04	04	STEP TUBE	304 STAINLESS STEEL	ASTM A213	1.0 X 0.065 RND. TUBE
2	82740-03	03	CLAMP	6061-T6 ALUMINIUM	QQ-A-200/8	1.0 X 3.5 BAR
1	82740-02	02	SOCKET	6061-T6 ALUMINIUM	QQ-A-200/8	2.5 X 2 BAR
1	82740-01	01	STEP ASSEMBLY			
01						

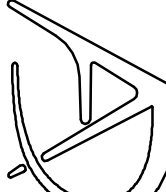
LIST OF MATERIALS

- NOTES
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
  2. WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
  3. THOROUGHLY DEGREASE AND ALDINE SOCKET (02) PRIOR TO ASSEMBLY WITH STEP TUBE. THOROUGHLY DEGREASE, PRIME AND PAINT SOCKET AND STEP TUBE AFTER ASSEMBLY WITH SPRING PIN. ALTERNATE: THOROUGHLY DEGREASE AND POWDER COAT SOCKET AND STEP TUBE AFTER ASSEMBLY. APPLY GRIP TAPE (12) TO TOP SURFACE OF STEP TUBE AFTER PAINTING OR POWDERCOATING.
  4. THOROUGHLY DEGREASE, ALDINE, PRIME AND PAINT STRAP (03) PRIOR TO ASSEMBLY. ALTERNATE: THOROUGHLY DEGREASE AND POWDERCOAT STRAP (03) PRIOR TO ASSEMBLY.



01 STEP ASSEMBLY

APPROVALS		DATE
DRAWN: JEFF CLARKE	14 DEC 2009	
CHECKED: E. BURGIN		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX $\pm 0.010$ X.XX $\pm 0.03$ X.X $\pm 0.1$		
SCALE 1 : 1		
SHEET 1 OF 1		
DWG. SIZE A1		DWG. NO. 82740
		REV. 2

		
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